

Work Order ID 56717

March 5, 2010 9:59:52 AM



Page 1

Item ID: D412-742-041

Accept



Setup Start



Revision ID:

Item Name: Replacement Float Skidtube

Stop



Start Date: 05/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 17/03/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-3-5

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3391

Rev H

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

If D412-742-041 is a W/O on it's own,
Photocopy bluefile and create labels per PPP D412-742-041 CHG004

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56717

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Page 2

Item ID: D412-742-041

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Start Date: 05/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 17/03/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110



Hand Finish

Hand Finishing

HandFinishing

Memo

0.00

0.00

⇒ 10/07/19

X1 2

1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.
A/R ☐ Sikaflex-241/-291 ☐ M11514
Expiry date: ☐ 11/01

2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube, hand tighten only bolts with no sikaflex.
A/R ☐ Sikaflex-241/-291 ☐ M11514
Expiry date: ☐ 11/01

3-Remove "T" pins once sikaflex is dry.

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.
A/R ☐ LPS Procyon ☐ M104251

Pto →

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

8/06/20



Memo

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: DH12-742-041 PAR #: _____ Fault Category: skid to base NCR: Yes ~~No~~ DQA: ✓ Date: 10/7/27
 Resolution: rework Disposition: rework QA: N/C Closed: CKM Date: 10/7/27

NCR: <u>56717</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.07.19	110	Find saddle holes don't allow bolt to install R-C Process	<u>CP</u> 10.07.19 per Q51042	Acceptable to file inner holes to allow proper assembly.	<u>MM</u> 10-07-19	<u>S</u> 10/07/20	<u>CP</u> 10.07.19 Q51042	<u>S</u> 10/07/20

NOTE: Date & initial all entries

Work Order ID 56717

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Item ID: D412-742-041

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Setup Start



Revision ID:

Item Name: Replacement Float Skidtube

Stop



Start Date: 05/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 17/03/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

130



Packaging

Packaging

Operation
Description

Packaging

Memo

Identify and pack for shipping as per PPP D412-742-041 ☐ Location: _____ ☐ PPP Rev: _____

Set Up/
Run Hours

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

CW 6/7/23 @

10/07/26 JF

MF

10-7-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 56717



Parent Item: D412-742-041



Parent Item Name: Replacement Float Skidtube

Start Date: 05/03/2010

Required Date: 17/03/2010

Comments: IPP Rev A 05.10.13 New Issue
IPP Rev B 06.02.13 ECN 773 dwg @ rev.D
IPP Rev C 07-05-28 As per Rev F
IPP rev D 07.11.01 ecn 1053p

KJ/JLM
EC
JLM
EC

Start Qty: 1.00

Required Qty: 1.00

AN3C4A



BOLT

Purchased No

110 Each 1,649.000 24.0000



X

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1649

1114941
~~1114852~~

X24 48 10/07/19

112314

13

112720

12

112724

3

112829

1

112991

2

113121

64

113226

344

113644

110

113749

100

114103

500

114108

500

AN3C6A



BOLT

Purchased No

110 Each 718.0000 12.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

718

111982

718

X12 48 10/07/19

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Work Order ID: 56717

Parent Item: D412-742-041

Parent Item Name: Replacement Float Skidtube

Comments: IPP Rev A 05.10.13 New Issue
 IPP Rev B 06.02.13 ECN 773 dwg @ rev.D
 IPP Rev:C 07-05-28 As per Rev F
 IPP rev D 07.11.01 ecn 1053p

KJ/JLM
 EC
 JLM
 EC

Start Date: 05/03/2010

Required Date: 17/03/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C7A Purchased No 110 Each 485.0000 8.0000
 BOLT

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 485

105906 21

107376 252

113149 212

AN960C10L Purchased No 110 Each 388.0000 44.0000
 washer NAS1149C0332R

Warehouse Loc Qty Loc Code
Location

OFFSHORE

FG 100

103585 100

Main Warehouse

ST 288

112116 128

112612 160

x 8 24 10/09/19

1115000 x44 08/10/07/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 56717



Parent Item: D412-742-041



Parent Item Name: Replacement Float Skidtube

Start Date: 05/03/2010

Required Date: 17/03/2010

Comments: IPP Rev A 05.10.13 New Issue
IPP Rev B 06.02.13 ECN 773 dwg @ rev.D
IPP Rev C 07-05-28 As per Rev F
IPP rev D 07.11.01 ecn 1053p

KJ/JLM
EC
JLM
EC

Start Qty: 1.00

Required Qty: 1.00

AN960C416L

Purchased

No

110

Each

1,314.000 4.0000



WASHER



Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

44

104925

44

Main Warehouse

ST

1270

111916

2

112612

368

112794

500

112828

400

D3391-011



Fwd Tube Assembly

D3391-013



Mid Tube Assembly

D3391-015



Aft Tube Assembly

Manufactured

No

110

Each

0.0000

1.0000



X4 29 10/07/19

Manufactured

No

110

Each

0.0000

1.0000



X1 B56729 29 10/07/19

Manufactured

No

110

Each

0.0000

1.0000



X1 B56732 29 10/07/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 56717



Parent Item: D412-742-041



Parent Item Name: Replacement Float Skidtube

Start Date: 05/03/2010

Required Date: 17/03/2010

Comments: IPP Rev A 05.10.13 New Issue
IPP Rev B 06.02.13 ECN 773 dwg @ rev.D
IPP Rev: C 07-05-28 As per Rev F
IPP rev D 07.11.01 ecn 1053p

KJ/JLM
EC
JLM
EC

Start Qty: 1.00

Required Qty: 1.00

D3564-1

Manufactured No

110

Each

18.0000

1.0000



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	2	
33798	2	
Main Warehouse		
ST	16	
47531	1	
50270	1	
51676	14	

XI 10/07/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 56717



Parent Item: D412-742-041



Parent Item Name: Replacement Float Skidtube

Start Date: 05/03/2010

Required Date: 17/03/2010

Comments: IPP Rev A 05.10.13 New Issue
IPP Rev B 06.02.13 ECN 773 dwg @ rev.D
IPP Rev C 07-05-28 As per Rev F
IPP rev D 07.11.01 ecn 1053p

KJ/JLM
EC
JLM
EC

Start Qty: 1.00

Required Qty: 1.00

D3564-3

Manufactured No

110

Each

19.0000

1.0000



Wearshoe

Warehouse
Location

Loc Qty

Loc Code

OFFSHORE

FG

2

33764

2

Main Warehouse

FP

5

50113

5

Main Warehouse

FP19

11

55489

11

Main Warehouse

ST

1

46445

1

x1 10/07/19

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 56717

Parent Item: D412-742-041

Parent Item Name: Replacement Float Skidtube

Comments: IPP Rev A 05.10.13 New Issue
IPP Rev B 06.02.13 ECN 773 dwg @ rev.D
IPP Rev C 07-05-28 As per Rev F
IPP rev D 07.11.01 ecn 1053p

KJ/JLM
EC
JLM
EC

Start Date: 05/03/2010

Required Date: 17/03/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-5

Manufactured No

110

Each

36.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

2

34806

2

Main Warehouse

FP19

32

51925

1

54772

6

55024

12

55333

13

Main Warehouse

ST

2

45824

1

47433

1

358709

81 41 10/07/19

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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7

Work Order ID: 56717



Parent Item: D412-742-041



Parent Item Name: Replacement Float Skidtube

Start Date: 05/03/2010

Required Date: 17/03/2010

Comments: IPP Rev A ☐ 05.10.13 ☐ New Issue ☐
 IPP Rev B ☐ 06.02.13 ☐ ECN 773 dwg @ rev.D
 IPP Rev: C 07-05-28 As per Rev F
 IPP rev D 07.11.01 ecn 1053p

KJ/JLM ☐
 EC
 JLM
 EC

Start Qty: 1.00

Required Qty: 1.00

D3566-1 Manufactured No 110 Each 23.0000 2.0000



Gasket

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

FP

18

B59126

X2 2/10/07/19

52512

3

54480

1

55011

1

55320

13

Main Warehouse

ST

5

46349

1

51218

1

51259

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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8

Work Order ID: 56717



Parent Item: D412-742-041



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Start Date: 05/03/2010

Required Date: 17/03/2010

Comments: IPP Rev A 05.10.13 New Issue
IPP Rev B 06.02.13 ECN 773 dwg @ rev.D
IPP Rev: C 07-05-28 As per Rev F
IPP rev D 07.11.01 ecn 1053p

KJ/JLM
EC
JLM
EC

Start Qty: 1.00

Required Qty: 1.00

D3566-5 Manufactured No

110 Each 26.0000 1.0000



Gasket

Warehouse	Loc Qty	Loc Code
Location		

Main Warehouse

FP19	22	
55026	10	
55335	12	

Main Warehouse

ST	4	
36113	1	
46186	1	
47318	1	
51260	1	

1359158

41 10/07/19

D3591-1 Manufactured No

110 Each 37.0000 2.0000



Bushing

Warehouse	Loc Qty	Loc Code
Location		

Main Warehouse

ST	37	
46105	29	
47121	8	

1357350

41 10/07/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 56717



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Start Date: 05/03/2010

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Comments: IPP Rev A 05.10.13 New Issue
IPP Rev B 06.02.13 ECN 773 dwg @ rev.D
IPP Rev: C 07-05-28 As per Rev F
IPP rev D 07.11.01 ecn 1053p

KJ/JLM
EC
JLM
EC

Start Qty: 1.00

Required Qty: 1.00

D3672-3 Manufactured No

110 Each 524.0000 4.0000



Phenolic Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST117

24

B57704

x4 28 10/07/19

- 51596

24

Main Warehouse

ST77

500

55560

500

MS27039C4-12 Purchased No

110 Each 22.0000 4.0000



SCREW

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

22

M114221

x2 28 10/07/19

2726

4

2296

2

5558

16

x2 28 10/07/19

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Shop Packet Print

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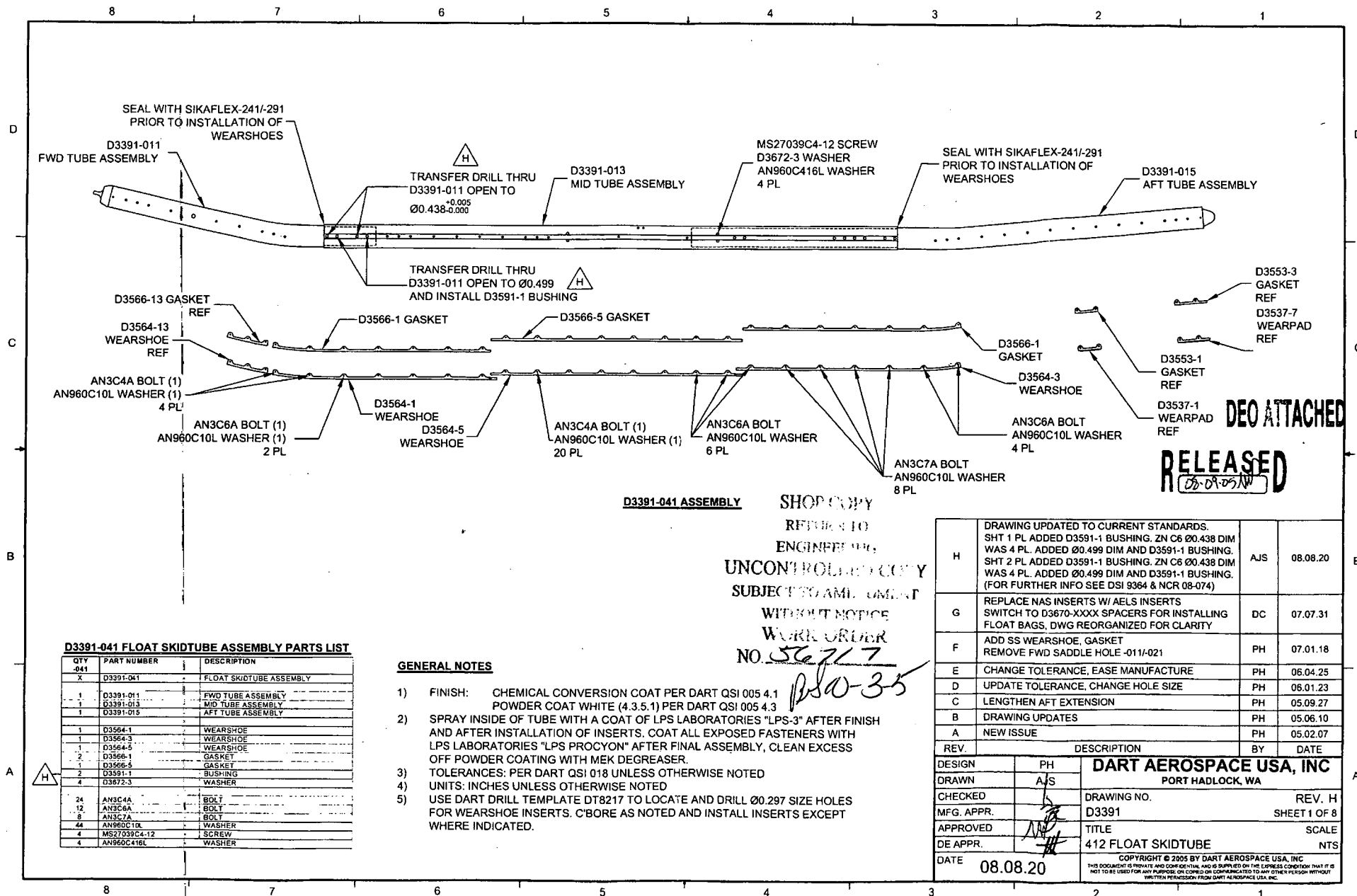
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

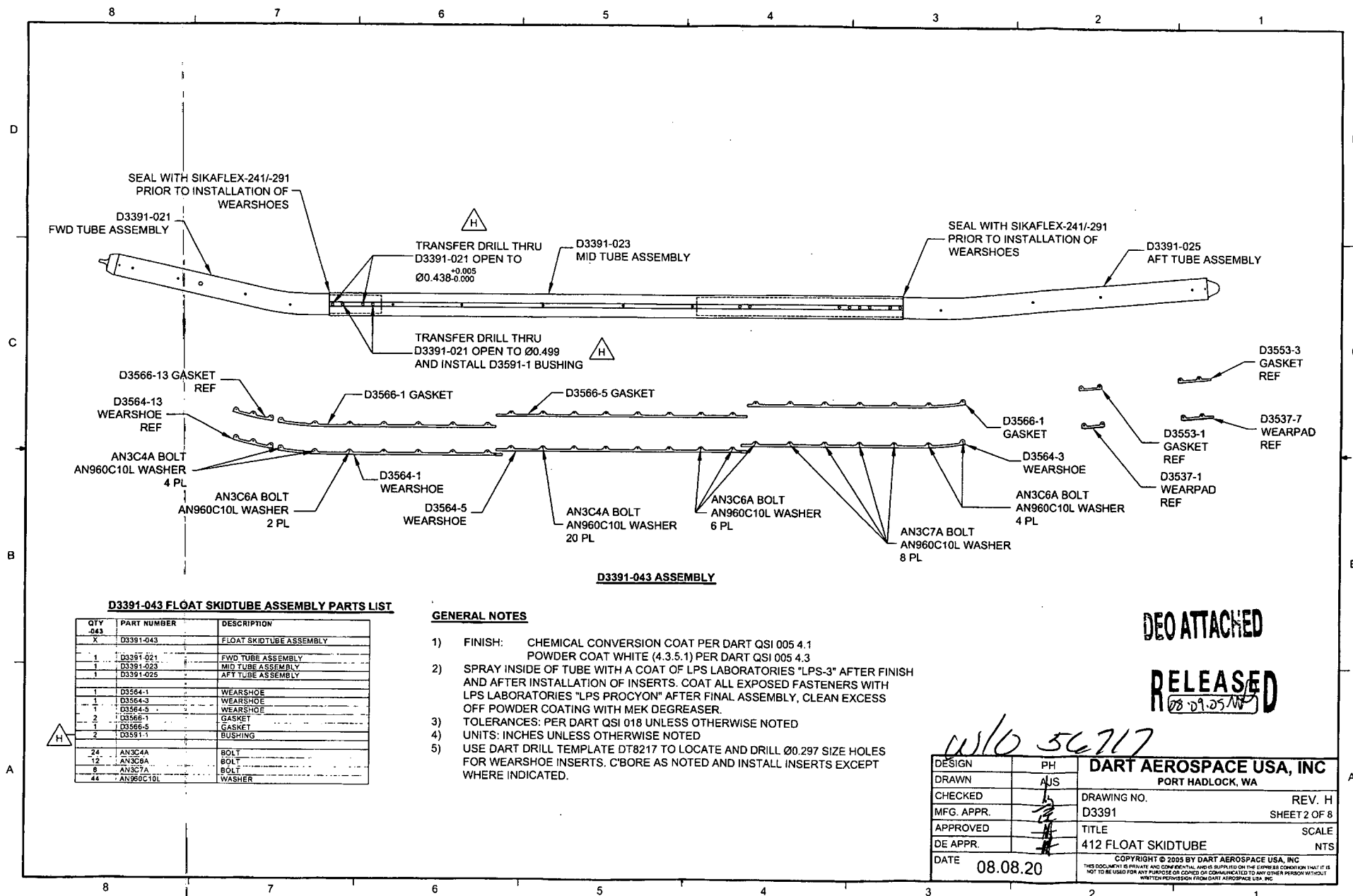
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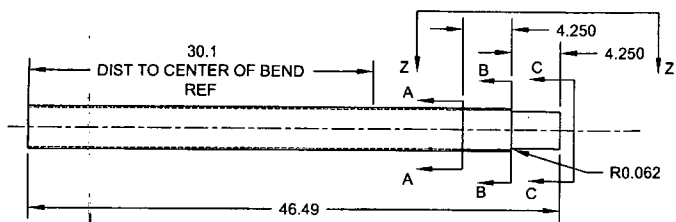
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

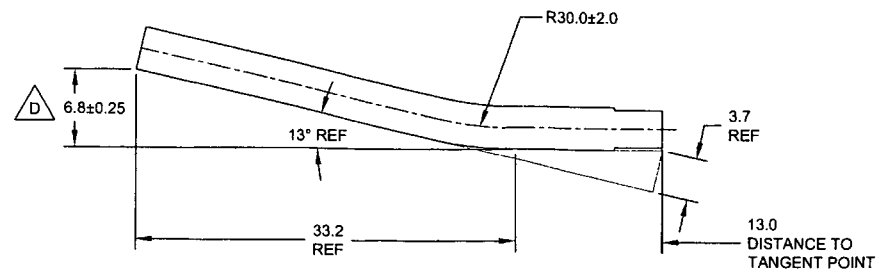
NOTE: Date & initial all entries



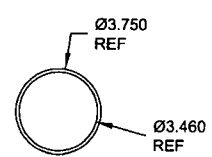




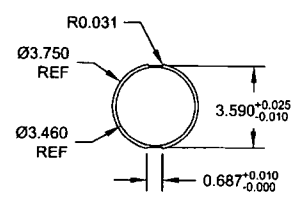
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



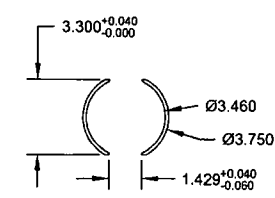
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



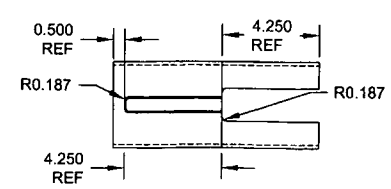
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X

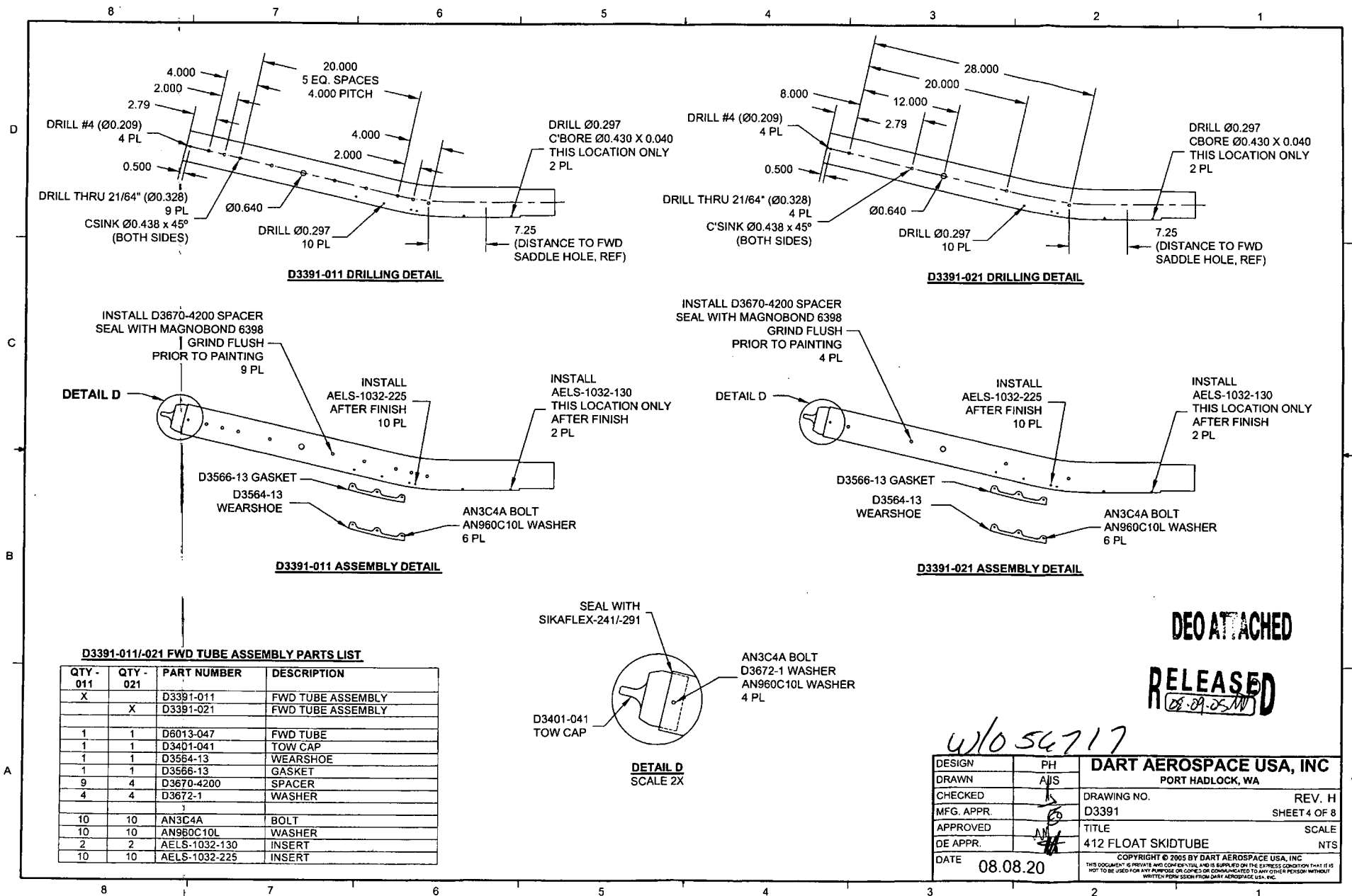


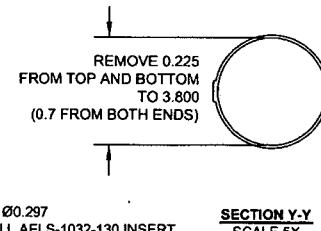
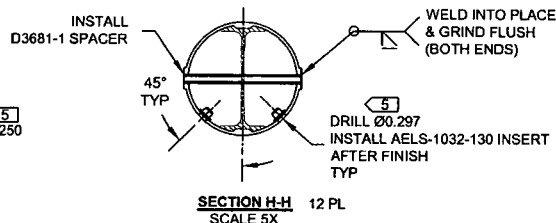
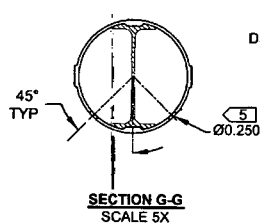
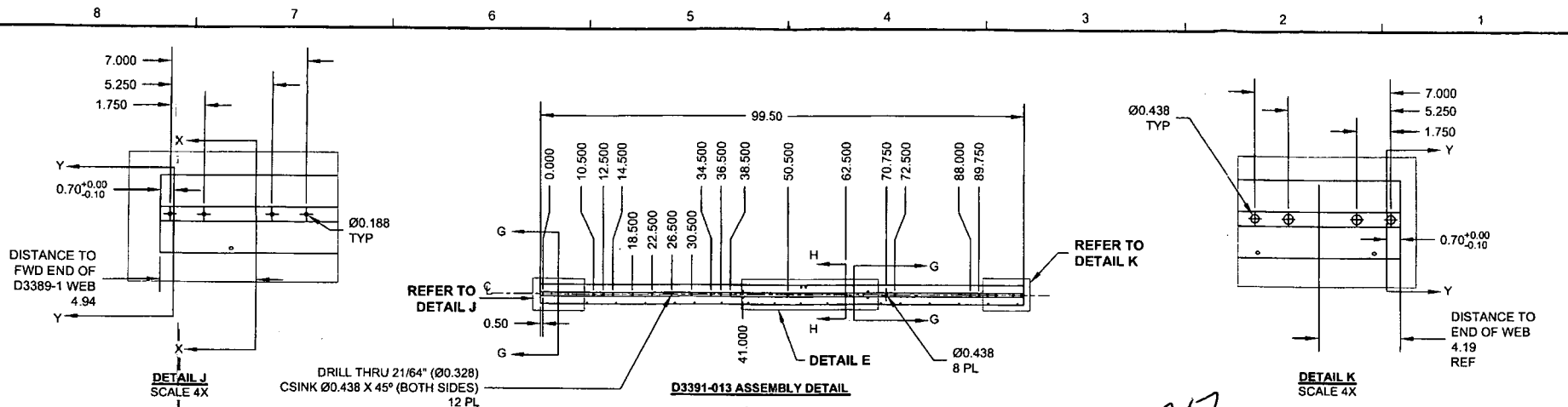
VIEW Z-Z
SCALE 2X

DEO ATTACHED
RELEASED
28 JAN 05 NW

WLO 56217

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D3391	REV. H
MFG. APPR.		TITLE	SHEET 3 OF 8
APPROVED		412 FLOAT SKIDTUBE	SCALE
DE APPR.			NTS
DATE	08.08.20	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



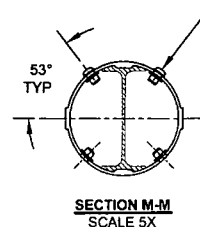
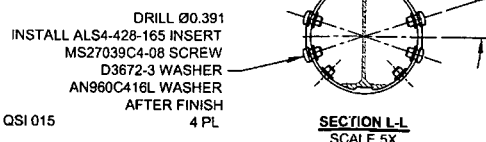
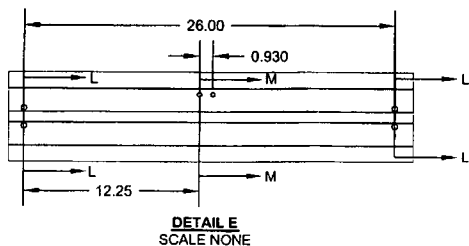


D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
-013		
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

D3391-013 MID TUBE ASSEMBLY

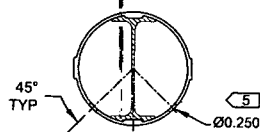
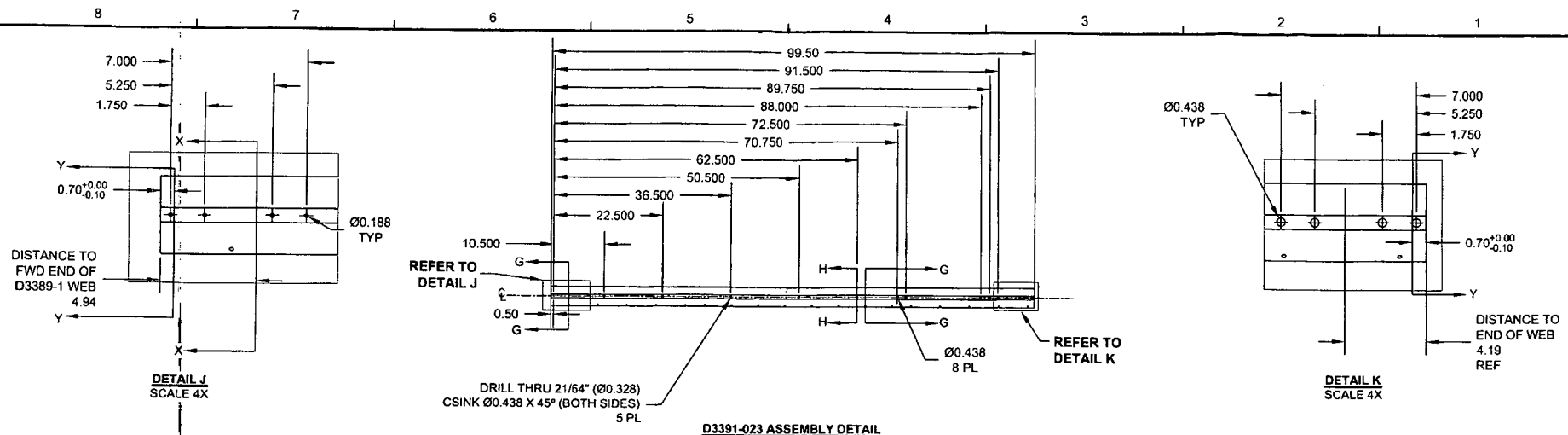
- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- WELDING: PER DART QSI 004



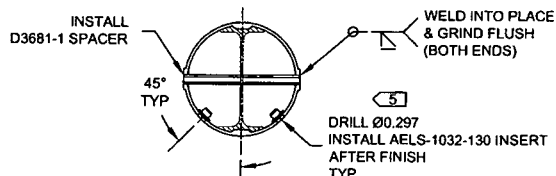
DEO ATTACHED

RELEASED

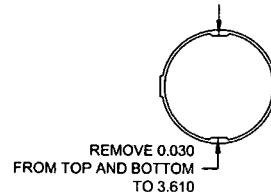
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEETS OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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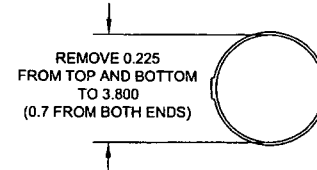
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



SECTION Y-Y
SCALE 5X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

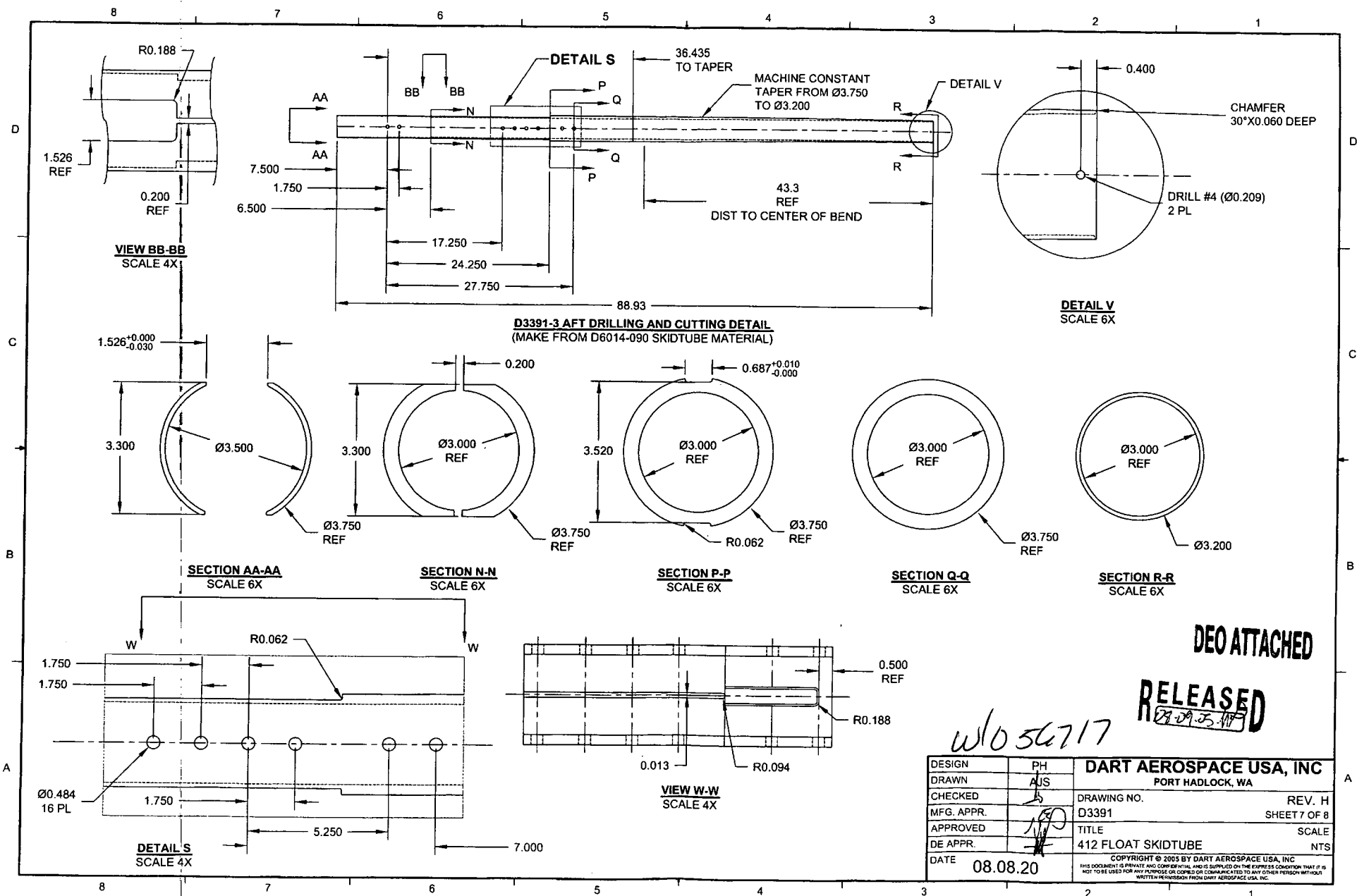
D3391-023 MID TUBE ASSEMBLY

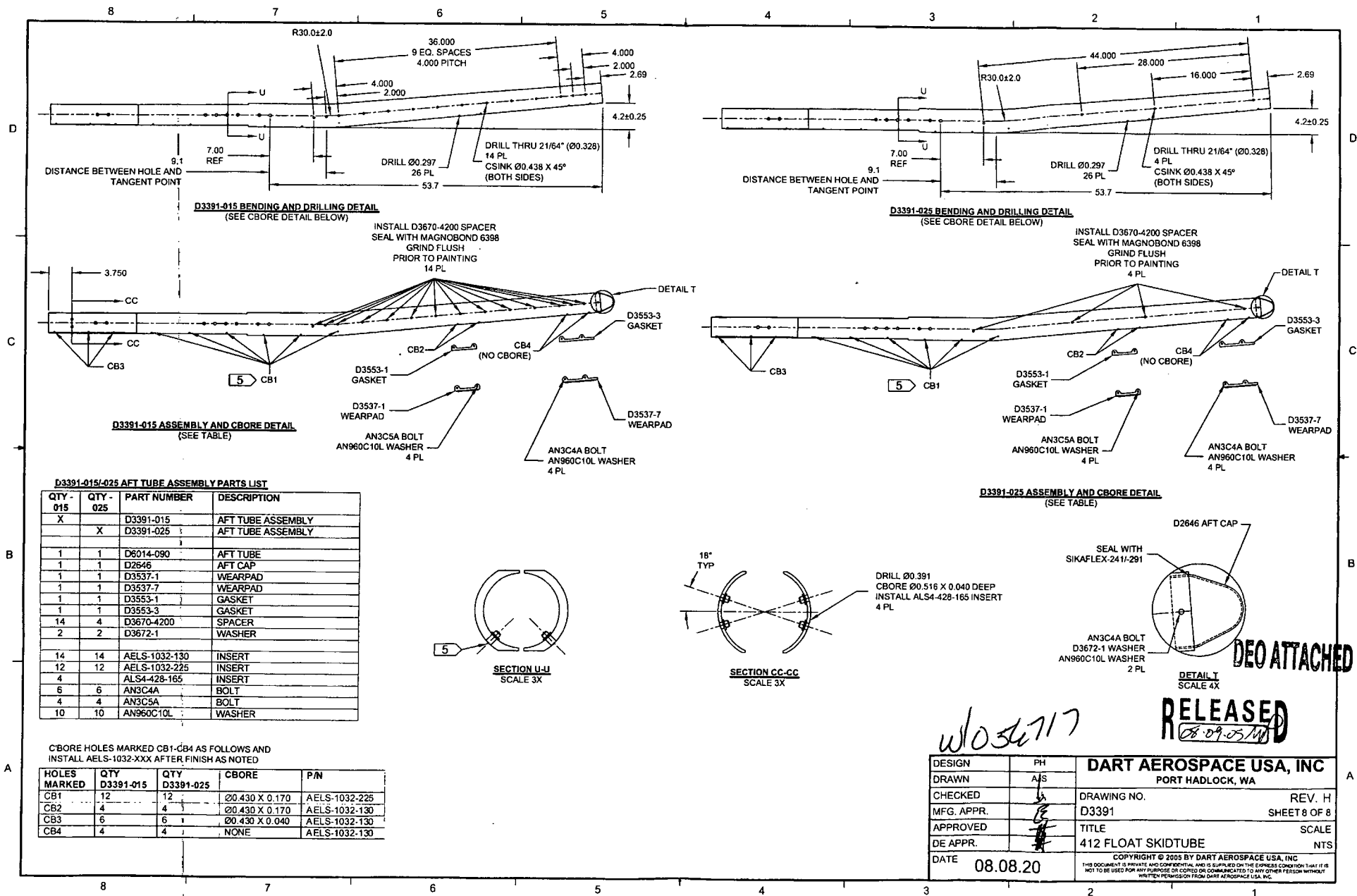
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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DEO ATTACHED
RELEASED
08-09-25-14

W1056717





DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CP</i>	CHECKED <i>h</i>	MFG. APPR. <i>M</i>	APPROVED <i>MP</i>		DE APPR. <i>h</i>		
DATE 09.09.23	DATE <i>06.09.24</i>	DATE <i>09/09/25</i>	DATE <i>09/09/30</i>		DATE <i>09/09/30</i>		

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
 OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
 2010-02-02

MP

W/O 56717

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